

Work Order ID 75829

November-01-11 7:49:24 AM

75829

Page 1

Item ID: D1038-58B Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fastener Rail, Black
 Start Date: 01/11/2011 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 18/11/2011 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 11/11/01 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D1038	Rev B

100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Create white labels and bag them								

Handwritten: MLJ 12-1-25
 50

110	BAND SAW	0.00							
110									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut extrusion D2023 to length 21.81" (+0.06/-0.00)								

Handwritten: 136

120	HAAS CNC VERTICAL MACHINING #1	0.00							
120									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1- Mill as per Folio FA783 Rev: <u>AA</u> & Dwg D1038 Rev: <u>3</u> 2-Deburr per dwg D1038								

Handwritten: 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC2- Inspect parts off machine FAI/FAIB	0.00							
130									
QC	Memo	0.00	BC	11/11/12		50	1		
Quality Control									
140	QC8- Inspect parts - second check	0.00							
140									
QC	Memo	0.00				50	0		
Quality Control									
150		0.00							
150									
Small Fab	Small Fab	0.00							
Small Fab	Memo								
Small Fab	Deburr								

GP 11/11/18 (S)

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>count</u> <u>50</u>			
170 *170* Outsource4 Outsource process - Anodize	Outsource process-Anodize per QSI017 4.1.10.1 Memo Issue P/O: <u>15506</u> Black Anodize as per Dwg D1038	0.00 0.00						<u>CZ 11/11/22</u>	<u>50</u>
180 *180* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo	0.00 0.00							<u>12/04/18</u> <u>(50)</u>

W/O:		WORK ORDER CHANGES					
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 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				count (50)			
200 *200* Small Fab Small Fab	Small Fab Memo 1-Stake 050 stainless steel wire per Dwg D1038-58 using DT8389 Batch: M 111948 2-Grind wire flush and deburr 3-Clean	0.00 0.00							12/01/24 (50)
210 *210* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				count (50)			

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	Packaging	0.00							
220									
Packaging	Memo	0.00							
Packaging	1-Pack each fastener rail into a cardboard tube 2-Roll Part in foam 3-Install red cap at each end and secure with tape. 4-Apply white labels to cardboard tubes 5-Identify and Stock Location: <u>FG 2</u>								
230	QC21- Final Inspection - Work Order Release	0.00							
230									
QC	Memo	0.00							
Quality Control									

(50x) SP 12-01-26

12/1/30

12-01-30
(50)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

November-01-11 7:49:29 AM

Page 1

Work Order ID: 75829

75829

Parent Item: D1038-58B

D1038-58B

Parent Item Name: Fastener Rail, Black

Start Date: 01/11/2011

Required Date: 18/11/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: E 03.05.02 Reformat; Added label KJ/RF
IPP Rev:F 06-08-16 Updated Packaging Procedures JLM
IPP Rev:G 08-09-16 Added Folio # JLM Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2023		Manufactured	No			110	f	1,223.700	1.903	95.15			

D2023

Extrusion, Fastener Rail

**

Location

Loc Qty

Loc Code

MAT006

1223.7

21907

1223.7

91.25

86 11/11/11

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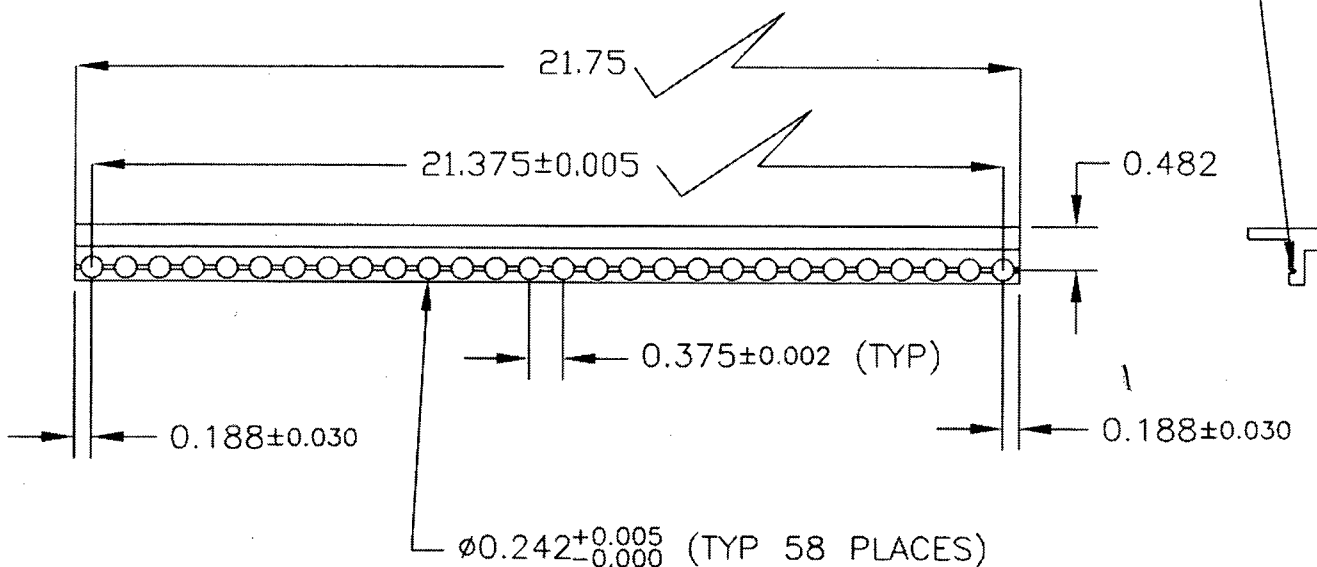
NOTE: Date & initial all entries



RELEASED

05.03.31

STAKE $\phi 0.50$ TYPE 302 STAINLESS
STEEL WIRE FULL LENGTH
(REF DART SPEC M302SW.050)



D1038-58 1/4 TURN FASTENER RAIL

- 1) MAKE FROM D2023 EXTRUSION
- 2) FINISH: D1038-58 - NONE
D1038-58B - ANODIZE BLACK PER DART QSI 017 4.1.10
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75829

M.L.J.
11/11/01

DESIGN	DRAWN BY	DART AEROSPACE LTD
05.02.02	91.05.05	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
05.02.02	04.05.14	D1038
DATE	05.02.02	TITLE
		1/4 TURN FASTENER RAIL
		NEW ISSUE
		UPDATE TOLERANCE
		REDRAWN, UPDATE NOTES
		REV. B
		SHEET 1 OF 1
		SCALE
		NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15506

Purchase Order Date 11/22/11

PO Print Date 1/04/12

Page Number 1 of 2

Order From :

VC-AND002

ANODIZING & PAINT T.N.M. INC.
21 AVIATION ROAD
POINTE CLAIRE, QC H9R 4Z2
CA

Contact Name

Vendor Phone

514 429 7777

Vendor Fax

514 429 5108

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

RECEIVED

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
2	76529	D4410-3 FACE PLATE	1/06/12 Yes	3.00	FedEx PI collect	\$1.6000	\$4.80
		Special Inst: D4410-3 BLACK ANODIZE B76529 ANODIZE PER MIL-A-8625F TYPE I/IB/IC/II OR IIB CLASS 2					
3	75081	D2348 WEARPLATE	1/06/12 Yes	23.00	FedEx PI collect	\$1.6000	\$36.80
		Special Inst: D2348 BLACK ANODIZE B75081 ANODIZE PER MIL-A-8625F TYPE I/IB/IC/II OR IIB CLASS 2					
4	75829	D1038-58B FASTENER RAIL	1/06/12 Yes	50.00	FedEx PI collect	\$1.6000	\$80.00

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 4

Change Date: 1/04/12



SHIPPING ADVICE BON DE LIVRAISON



C of C Number : 209436

Customer

DART AEROSPACE

1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
TEL # 613-632-9577
FAX # 613-632-1053

Shipping Address

1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
TEL # 613-632-9577
FAX # 613-632-1053

PO Number: PO15506

Cert Rev: 0

Ship date: 2012-01-18

C of C Generator: Waqas

LINE ITEM DETAIL - PARTS DESCRIPTION

Item #	Part Number	Dash	Serial Number	Lot/Batch Number	PO Line Item #	Rec	Rej	Ship	Additional Information
1	TEmples BLACK ANODIZE MIL-8625				001	3	0	3	Refer to C of C for specific details
2	TEmples BLACK ANODIZE MIL-8625				002	23	0	23	Refer to C of C for specific details
3	TEmples BLACK ANODIZE MIL-8625				003	50	0	50	

Transport/FOB Point:

I hereby take possession of the goods mentioned above and acknowledge that parts are packaged properly and no visual damage is apparent on parts / Packaging.
Je prends possession des biens ci-haut mentionnés et confirme que les pièces ont été emballées de façon adéquate et ne présente pas de dommage apparent aux pièces / emballage.

Signature: _____ Date: _____



**CERTIFICATE OF CONFORMITY
CERTIFICAT DE CONFORMITÉ**



C of C Number :		209436	
Cert Rev	0	DWG Rev	
Page:		1 of 1	
C of C date		18 Jan 2012	
PO Number :		P015506	

Customer
DART AEROSPACE 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7 TEL # 613-632-9577 FAX # 613-632-1053

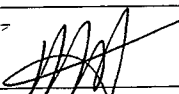
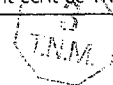
C of C Generator	Waqas
Material	

51261/20

LINE ITEM DETAIL - PARTS DESCRIPTION									
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1	TEmples BLACK ANODIZE MIL-8625				001	3	0	3	76529/D4410-3, FACE PLATE
2	TEmples BLACK ANODIZE MIL-8625				002	23	0	23	75081/D2348
3	TEmples BLACK ANODIZE MIL-8625				003	50	0	50	D1038-58B

THE FOLLOWING PROCESS(ES) WERE APPLIED TO THE COMPONENTS MENTIONNED ABOVE				
#	Required Process Name	Spec Number	Rev.	Process description
1	Sulphuric Acid Anodize Per MIL-A-8625 BLACK	MIL-A-8625	F, AMENDMENT 1	BLACK ANODIZE PER MIL-A-8625 rev F1 TYPE II CLASS 2

Customer Additional Info:	
<p>This certifies that all parts are processed, tested and inspected to the requirements of the above requirements / Specification. Travel Card have been completed, filed and are available for review upon request.</p> <p>Nous certifions que les Pièces énumérées ci-haut ont été traitées et inspectées selon les requis / Spécifications mentionnés. Les feuilles de Route (Travel card) ont été complétées, classées et sont disponibles pour consultation sur demande.</p> <p>Importante Notice: Painted Parts will be Fully Solvent Resistant after 7(seven) Full Days of Air Curing at Ambient Temperatures. Any modification/Rework to the components without express written agreement from TNM will invalidate this certificate.</p> <p>Notice importante: Les pièces peintes seront complètement résistantes au solvant après 7(sept) jours complets de séchage à l'air ambiant. Quelques Modifications / Réparations que ce soit, faites aux composantes, sans le consentement écrit de TNM invalideront ce Certificat.</p>	

Signature:  Stamp:  Date: Jan 18, 2012

Template Name/Rev: Certificate of Conformity Rev X